

Work Order ID 65069

Thursday, January 06, 2011 10:38:06 AM



Page 1

Item ID: D2282-5

Accept



Setup Start



Revision ID:

Item Name: Tube

Stop



Start Date: 1/6/2011 Start Qty: 60.00



Cust Item ID:

Required Date: 1/13/2011 Req'd Qty: 60.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 1-01-12

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2282

Rev E

100

0.00



DOOSAN LATHE

Doosan

Memo

0.00

Doosan Lathe

1-Turn as per Dwg D2282 and Folio FA189
2-Deburr

ENSURE TO USE 304 SS ONLY

303 SS IS NOT ACCEPTABLE

[Signature] 1/11/12

[Signature]

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

[Signature] 1/11/12

[Signature]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

130

Identify as per dwg & Stock Location: _____

0.00



Packaging

Identify cell

Memo

0.00

Packaging

*****STOCK IN LARGE FAB*****

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/01/13

61

11/01/13 *(61)*

11/01/14

11/01/14

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Picklist Print

Thursday, January 06, 2011 10:38:11 AM

Page 1

Work Order ID: 65069

Parent Item: D2282-5

Parent Item Name: Tube



Start Date: 1/6/2011

Required Date: 1/13/2011

Start Qty: 60.00

Required Qty: 60.00

Comments: IPP Rev:A Removed from 9 Digit 05-12-02 JLM
IPPR Rev:B Now on Doosan Lathe 08-06-05 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304RO.750

*

Purchased

No

100

f

48.0000

0.18006

11.37221



304 SS Roundbar .750

SA 11/11/13

Location

Loc Qty

Loc Code

MAT

48

116501

48

MAT028

3.68421E-05

113216

3.6842E-05

12.1 Rf

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	65069
Description: Handle Tube		Part Number:	D2282-5
Inspection Dwg: D2282 Rev: E		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.17	+/-0.030	2.168	/		Veil	SN-9
R0.063	+/-0.010	R.063	/			
0.063	+/-0.010	.063	/			
0.125	+/-0.010	.125	/			
0.090 x 45°	+/-0.010	.090x45°	/			
R0.350	+0.010/-0.000	R.350	/			
0.158	+/-0.010	.155	/			
Ø0.386	+0.005/-0.000	Ø.390	/			
Ø0.700	+/-0.010	Ø.699	/			

Measured by:	<i>[Signature]</i>	Audited by:	<i>[Signature]</i>	Prototype Approval:	N/A
Date:	11/11/12	Date:	11/01/13	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.11.11	New Issue P/O D350-615-041	KJ/RF	
B	05.04.19	Dimensions & tolerances changed	KJ/JLM	
C	06.03.15	Dimensions & tolerances revised per Dwg Rev E	KJ/JLM	
D	07.11.26	Ø0.700 dimension added	KJ/EC/DD	<i>[Signature]</i>

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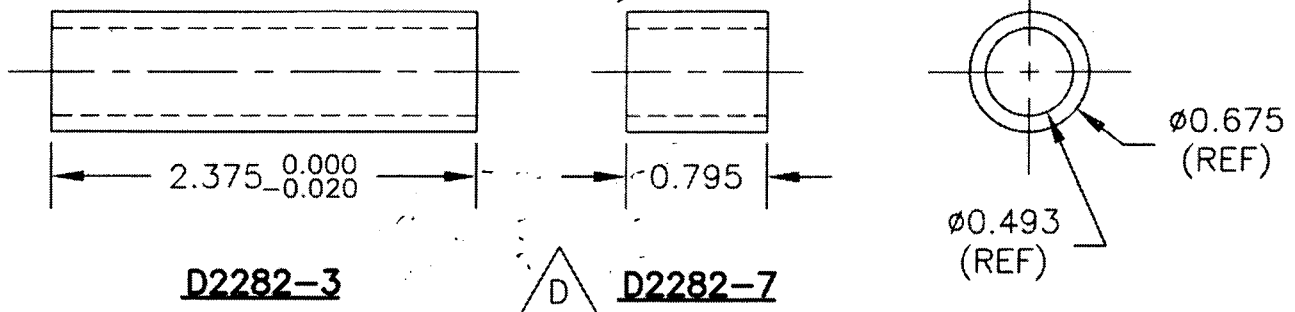
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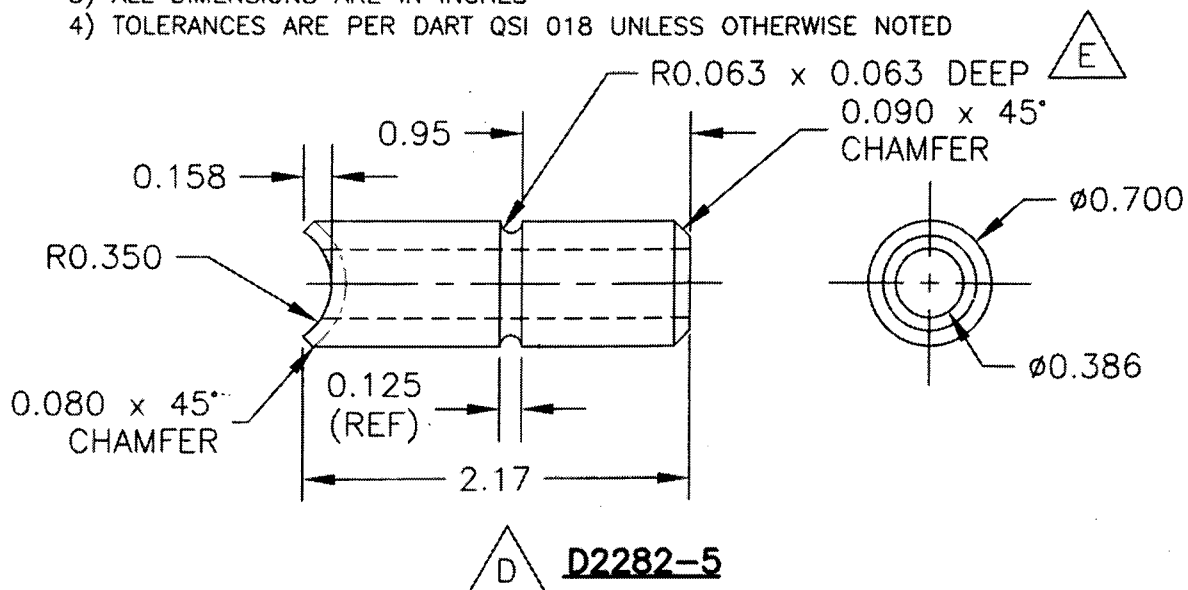
NOTE: Date & initial all entries

DARTSHOP COPY
RETURN TO
ENGINEERING

DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 1 OF 2
DATE 05.06.07	TITLE HANDLE TUBES		SCALE 1:1
A	94.10.14	NEW ISSUE	
B	95.03.23	RE-DESIGN	
C	97.10.20	CORRECTED NUMBERING SCHEME	
D	05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750	
E	05.06.07	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030	

**D2282-3/-7 TUBE:**

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**D2282-5 STEM:**

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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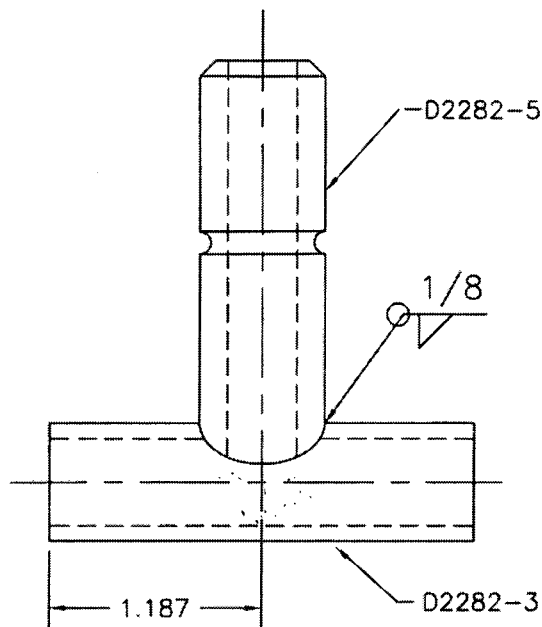
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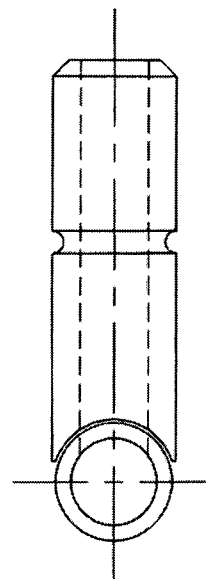
NOTE: Date & initial all entries



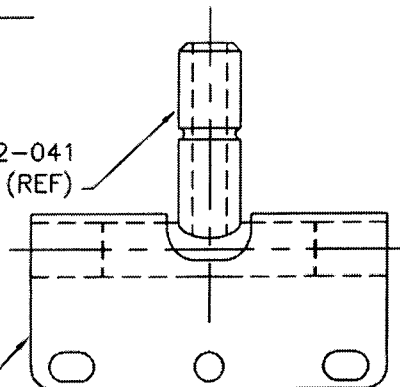
DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>UP</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 2 OF 2
DATE 05.06.07		TITLE HANDLE TUBES	SCALE 1:1



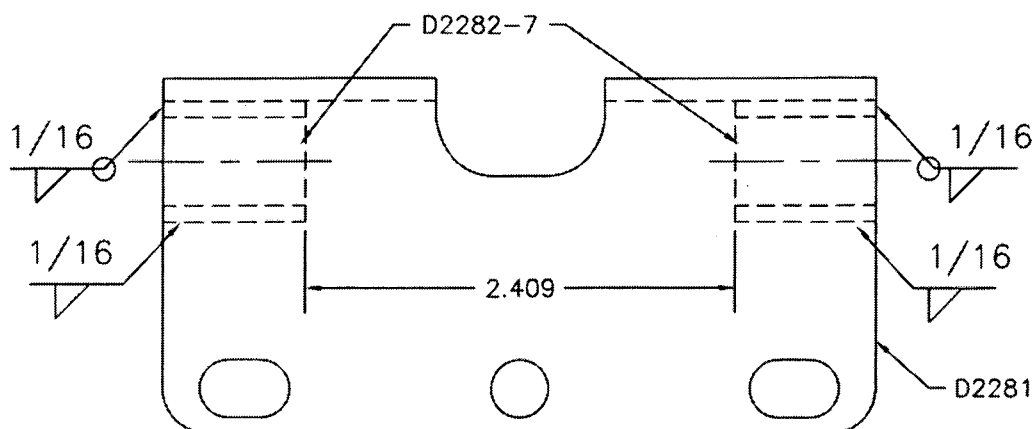
D2282-041 'T' ASSEMBLY
WELD ASSEMBLY PER DART QSI 004



D2282-041
(REF)



GENERAL ASSEMBLY
SCALE 1:2



D2282-043 SADDLE ASSEMBLY
WELD ASSEMBLY PER DART QSI 004

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